

Date: Wednesday, 3/12/2008 1:41:45 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SPACER BUSHING
Job Number	37851			
Estimate Number	10826			
P.O. Number			Part Number	D23273
This Issue	3/12/2008	S.O. No. :	Drawing Number	D2327 REV D
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type :	Drawing Revision	D
Previous Run	37541		Material	
Written By			Due Date	4/4/2008
Checked & Approved By			Qty:	50
Comment	Est. F 09.11.02	Removed 303 SS	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0375	304 SS ROUND BAR
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Comment: Qty.: 0.1641 f(s)/Unit	Total : 8.2058 f(s)
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Inventory

Material: AISI 304 Round Bar Ø0.375"

(M304R0.375)

Batch: M107403

MMF

50

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Deburr

MMF/mk/JF 08/04/10

08/04/10

50

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MMF/mk/JF 08/04/10

50

4.0	QC8	SECOND CHECK
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SECOND CHECK



Comment: SECOND CHECK

MMF/mk/JF 08/04/11

50

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8/4/14

50

50X

Identify and Stock

Location: 100411-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:41:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 37851

Part Number: D23273

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/14 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37851
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

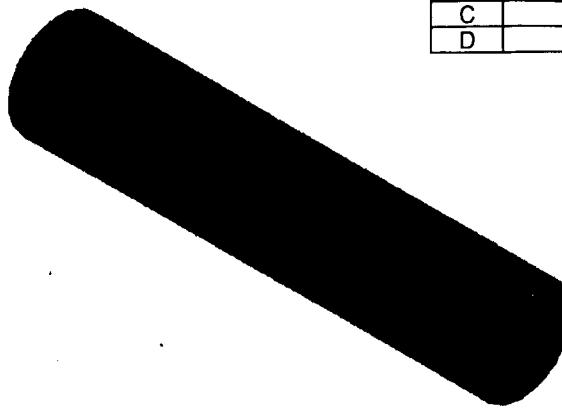
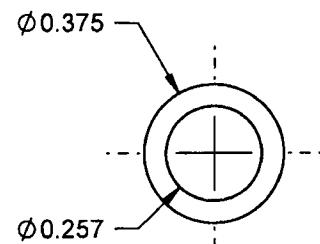
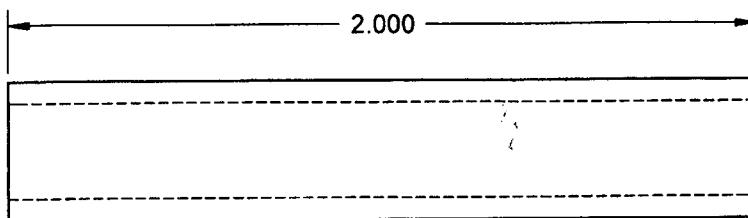
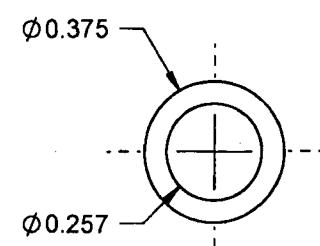
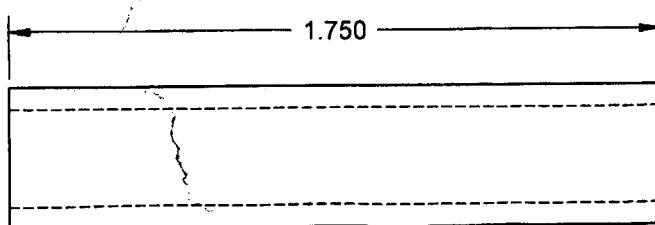
Measured by: <u>MMF /ml</u>	Audited by: <u>SG</u>	Prototype Approval:	N/A
Date: <u>03/04/09</u>	Date: <u>08.04.09</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1

REV	DATE	DESCRIPTION
A	94.12.17	NEW ISSUE
B	95.12.06	LENGTH CHANGE
C	03.05.13	303 SS SPEC ADDED
D	06.10.12	REMOVE 303 SS MATERIAL

**RELEASED**06.11.14 *CH***D2327-1 SPACER BUSHING****D2327-3 SPACER BUSHING**

37851

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

